

ASA

Date: Tuesday, 6/12/2007 3:00:38 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 32888	Part Number	: D34031
Estimate Number	: 11124	Drawing Number	: D3403 REV B
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 6/12/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: B
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Due Date	: 6/15/2007
Previous Run	: 31715	Qty:	100 Um: Each
Written By	:		
Checked & Approved By	: <i>[Signature] 07.06.12</i>		
Comment	: Est Rev: A 05.08.31 New issue KJ/JLM Est Rev: B 06-03-07 As per Rev B JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.2080 f(s)/Unit Total: 20.8000 f(s)
Material: AISI 303 SS Bar Ø0.750
(M303R0.750)
Identify for D3403-1
Batch: *M103884* *15" scrap* *11.6*

304 V
- M102085 / 50" 4.2 9.2
- M103857 / 34" 2.8 11.6
- M104392 / 26" X 2.2
- [unclear]
*DJP 07/06/16 **

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1- Turn as per Folio FA556 & Dwg D3403
Folio Rev: *B* Dwg Rev: *B*

RC 07/06/18

2-Deburr

DJP 07/06/16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RC 07/06/20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

RC 07/06/21

5.0 PACKAGING 1 PACKAGING RESOURCE #1




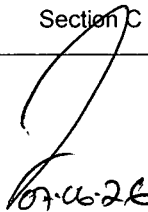
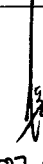

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *97*

07/06/22 (100)

*304 used M102085 50" [4.2]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.06.19	10	BUSHINGS MADE OUT OF 304SS (i.e. 31602085) INSTEAD OF 303SS.	 07.06.19	THIS DEVIATION IS ACCEPTABLE AS PER ATTACHED EMAIL FROM DAVID. SHEPHERD.	DSP 07.06.19	 07.06.26	 07.06.19	 07.06.26

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 32888

Part Number: D34031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



105

Comment: FINAL INSPECTION/W/O RELEASE

SP 07/06/26

Job Completion



u 07.06.22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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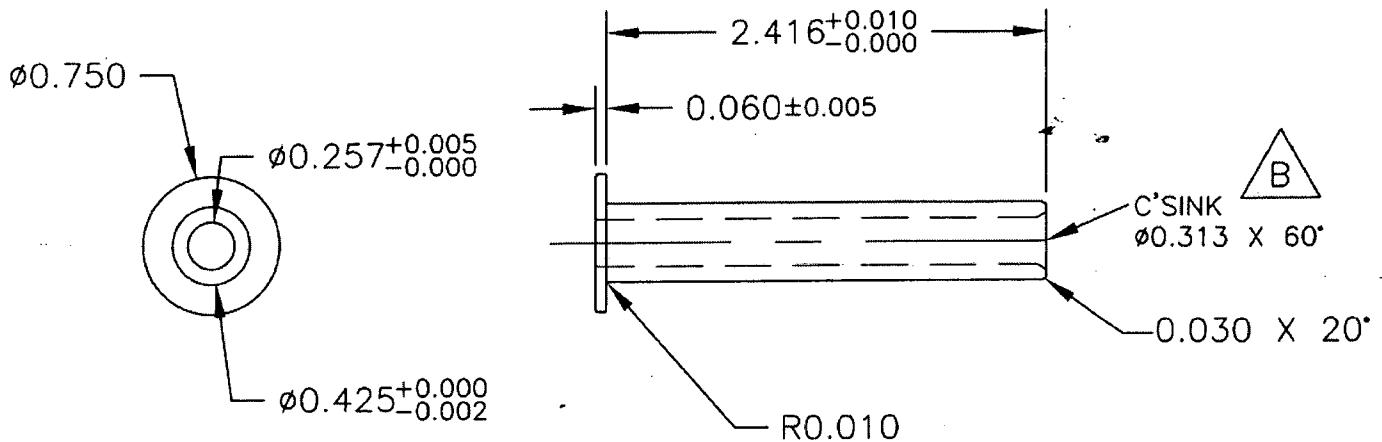
NOTE: Date & initial all entries



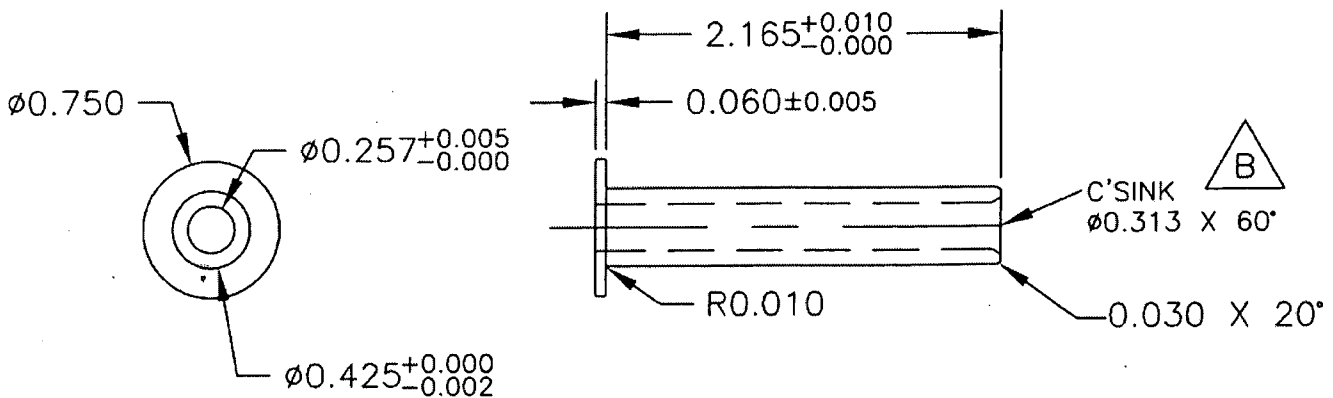
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3403	REV. B SHEET 1 OF 1
DATE 06.01.23		TITLE BUSHING	SCALE 1:1
A	05.03.07	NEW ISSUE	
B	06.01.23	ADD COUNTERSINK	

RELEASED

06.01.23



D3403-1 BUSHING



D3403-3 BUSHING

D3403-1/-3 BUSHING

- 1) MATERIAL: 0.750 AISI 303 ROUND BAR (REF. DART SPEC. M303R0150)
- 2) FINISH: NONE
- 3) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX
- 4) ALL DIMENSIONS ARE INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32888

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Marc Bellavance

From: David Shepherd [dshepherd@dartaero.com]
Sent: Tuesday, June 19, 2007 12:08 PM
To: 'Marc Bellavance'
Cc: 'L Lacelle'; 'Jason Murdoch'
Subject: RE: D3403-1 Bushings

Marc,

This is an acceptable deviation.

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Tuesday, June 19, 2007 9:35 AM
To: 'David Shepherd'
Subject: D3403-1 Bushings

Good morning David,

A quantity of 100 D3403-1 Bushing was machined recently out of different batch numbers of the same material (i.e. M303R0.750).

During the manufacturing process, an M304R0.750 was mistakenly used to manufacture a few bushings and it is not possible to differentiate the 304 SS from the 303 SS because all 100 bushings are stored in the same box.

Is it acceptable to have the bushings made out of 304 SS?

Marc

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.9.0/852 - Release Date: 6/17/2007 8:23 AM

No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.9.1/854 - Release Date: 6/19/2007 1:12 PM

6/19/2007